

Work Order ID 131354

April-06-15 9:21:03 AM

Final *131354*

Page 1

Item ID: D3914-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Long Basket Lid Assembly (350)
 Start Date: 4/06/15 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 4/07/15 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3914	C								
D4020	A								

100 Weld per dwg A/R S.S. rod Batch: *B125054* 0.00
 Large Fab
 100
 Large Fab
 Large Fab
 Memo 0.00
 1- assemble ribs , weld as per dwg D3914 using DT9607A
 2- weld hinge (3) and Mounting brackets as per dwg D3914
 Visual inspect before welding mesh
 3- tack weld mesh on basket as per dwg D3914
 Cut out mesh where label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label plate before tacking mesh

1x CC 15-4-9

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00
 QC
 110
 QC
 Quality Control
 Memo 0.00

1x
 DAS
 43
 9-89
 APR 09 2015

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo 124777	0.00							
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: 11:45 Oven Temperature: 320° Finish Time: 12:15								
140	Wing Walk as per dwg QSI005 4.4 Batch 111315	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***								

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>w/o</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

1 φ 15-11-10. DAS 34 989

1x φ 15/04/10

ML5 1504 10
ME
15-4-10

Picklist Print

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Work Order ID: 131354

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/06/15

Required Date: 4/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC
PER DWG REV.pc1 DD VERF:JLM
REV.C DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3914-1		Manufactured	No			100	Each	2.0000	2	2			
D3914-1													
Rib													

Location

Loc Qty

Loc Code

WA004

2

B130712

127308

2

D3914-7		Manufactured	No			100	Each	18.0000	2	2			
D3914-7													
Rib													

Location

Loc Qty

Loc Code

WA004

18

126961

1

127472

7

129838

10

D4018-5		Manufactured	No			100	Each	39.0000	9	9			
D4018-5													
Rib													

Location

Loc Qty

Loc Code

WA004

39

117453

39

Picklist Print

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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/06/15

Required Date: 4/07/15

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100 Each

10.0000

2 2

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

10

127809

2

129769

8

D2581

Manufactured No

100 Each

83.0000

2 2

D2581

Mounting Bracket

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

83

102265

38

127716

45

D2728-3

Manufactured Yes

140 Each

0.0000

0 0

D2728-3

Dart Logo Label Large

**

D4016-3

Manufactured No

100 Each

13.0000

3 3

D4016-3

Hinge Half, Lid

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

13

130006

13

D4020-5

Manufactured No

100 Each

4.0000

1 1

D4020-5

Mesh (350 Basket Long, Lid)

**

CC 15-4-9

Location

Loc Qty

Loc Code

WA004

4

129375

1

130358

3

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Shop Packet Print

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Picklist Print

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D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 4/06/15

Required Date: 4/07/15

Start Qty: 1.00

Required Qty: 1.00

D4021-3

Manufactured

No

100

Each

2.0000

1

1

D4021-3

CC 15-4-9

Data Plate

Location

Loc Qty

Loc Code

WA004

125833

2

2

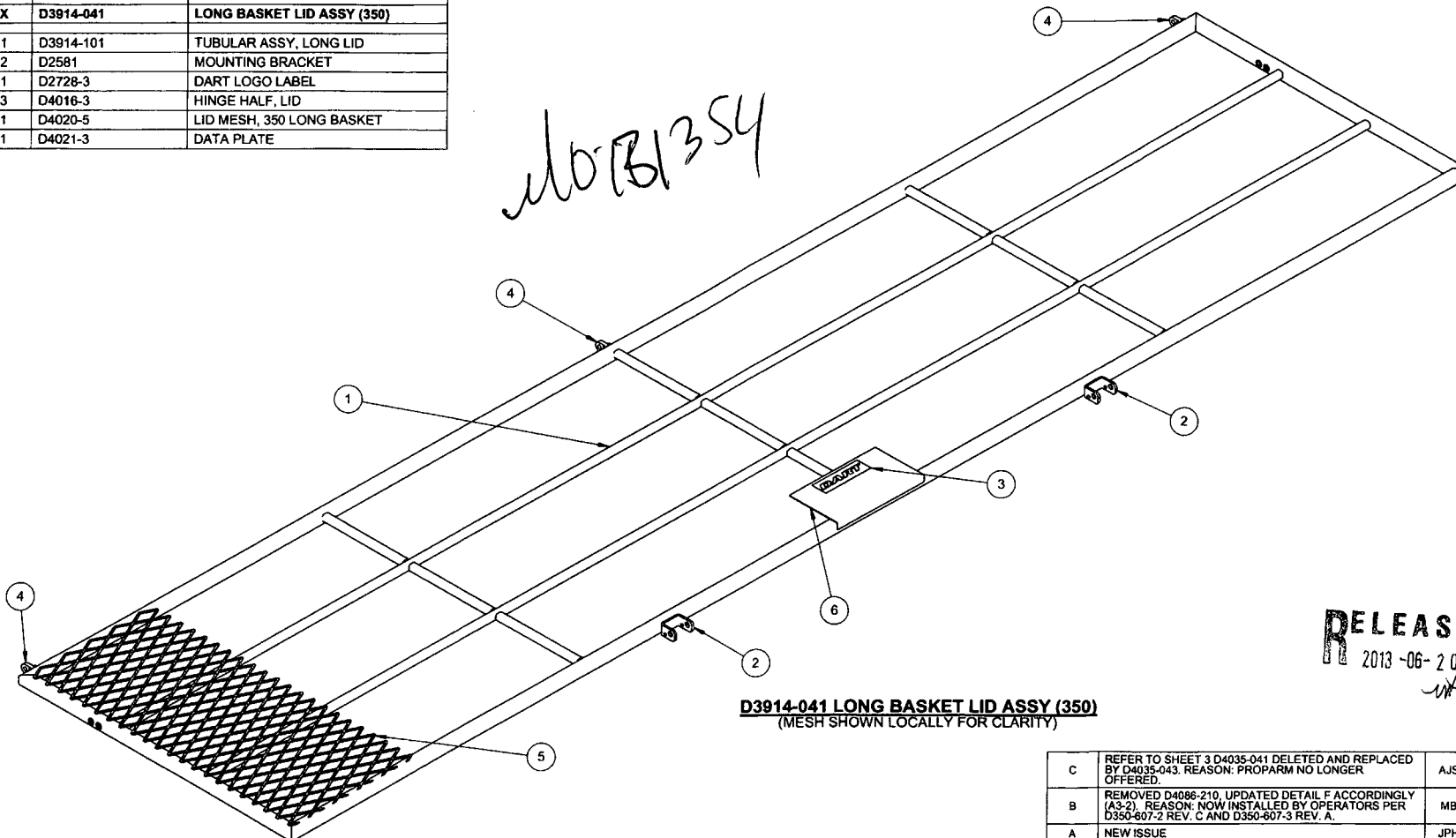
(IX)

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Shop Packet Print

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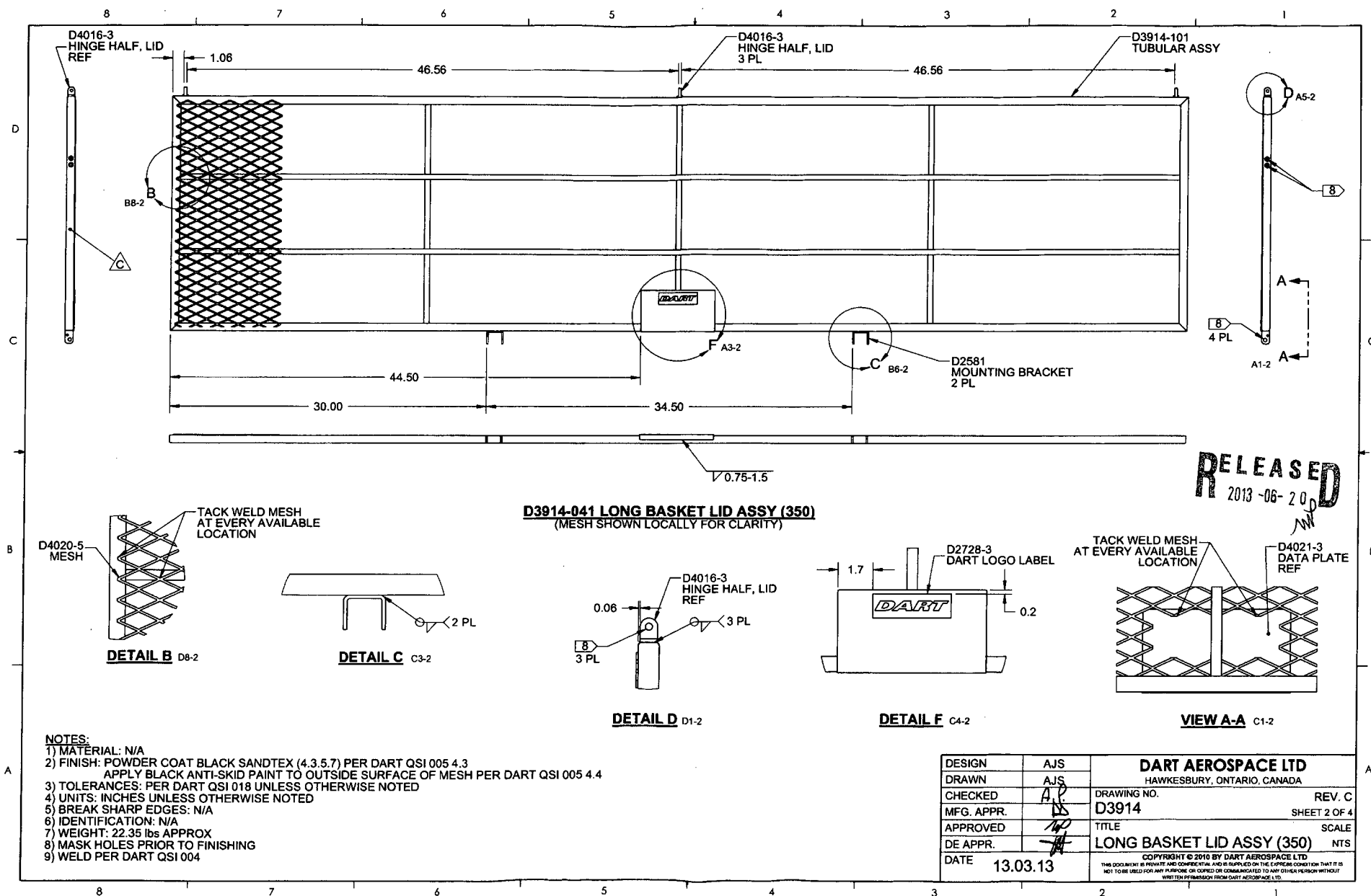
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
5	1	D4020-5	LID MESH, 350 LONG BASKET
6	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
2013-06-20

REV.	DESCRIPTION	BY	DATE
C	REFER TO SHEET 3 D4035-041 DELETED AND REPLACED BY D4035-043. REASON: PROPARM NO LONGER OFFERED.	AJS	13.03.13
B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. C
MFG. APPR.	DA	D3914	SHEET 1 OF 4
APPROVED	DA	TITLE	SCALE
DE APPR.	DA	LONG BASKET LID ASSY (350)	NTS
DATE	13.03.13	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	2	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3

D4035-043
RIB ASSY, AFT

D4035-043
RIB ASSY, AFT

TYP

E C2-3

TYP

E

5.93
REF

22.50

6.67
TYP

TYP

D3914-1
RIB
2 PL

D4018-5
RIB
9 PL

D3914-7
RIB
2 PL

23.25
TYP

8 D3914-101 TUBULAR ASSY, LONG LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D3914-101
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D3914	REV. C
MFG. APPR.	AJS	SHEET 3 OF 4	
APPROVED	AJS	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
DE APPR.	AJS	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	13.03.13		

RELEASED
2013-06-20

